

**Aero Design Ltd.****Work Order Control Sheet****Work Order#: 2016-97 Date Opened: 02 Aug 2016 Title: Assembly****Aircraft OEM: Bell Aircraft Model: 206B/206L/407 Product Type: Cyclic Friction Product Model: All Quantity: 2****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

N/A
N/A
JC
JC
N/A
JC
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

N/A
N/A

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
95210	1	Cyclic Friction Assy	JC
95201	1	Friction Installation	JC

**Traveller**

Initial or N/A


**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

2
N/A
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: Jason RekveSign: SCA: AD01Date: 02-Aug-16

ICC / Dual Inspection performed by:

Print: Jeff ClarkeSign: SCA: AD02Date: 02-Aug-16

Work Order closed by:

Print: Jeff ClarkeSign: SCA: AD02Date: 02-Aug-16

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

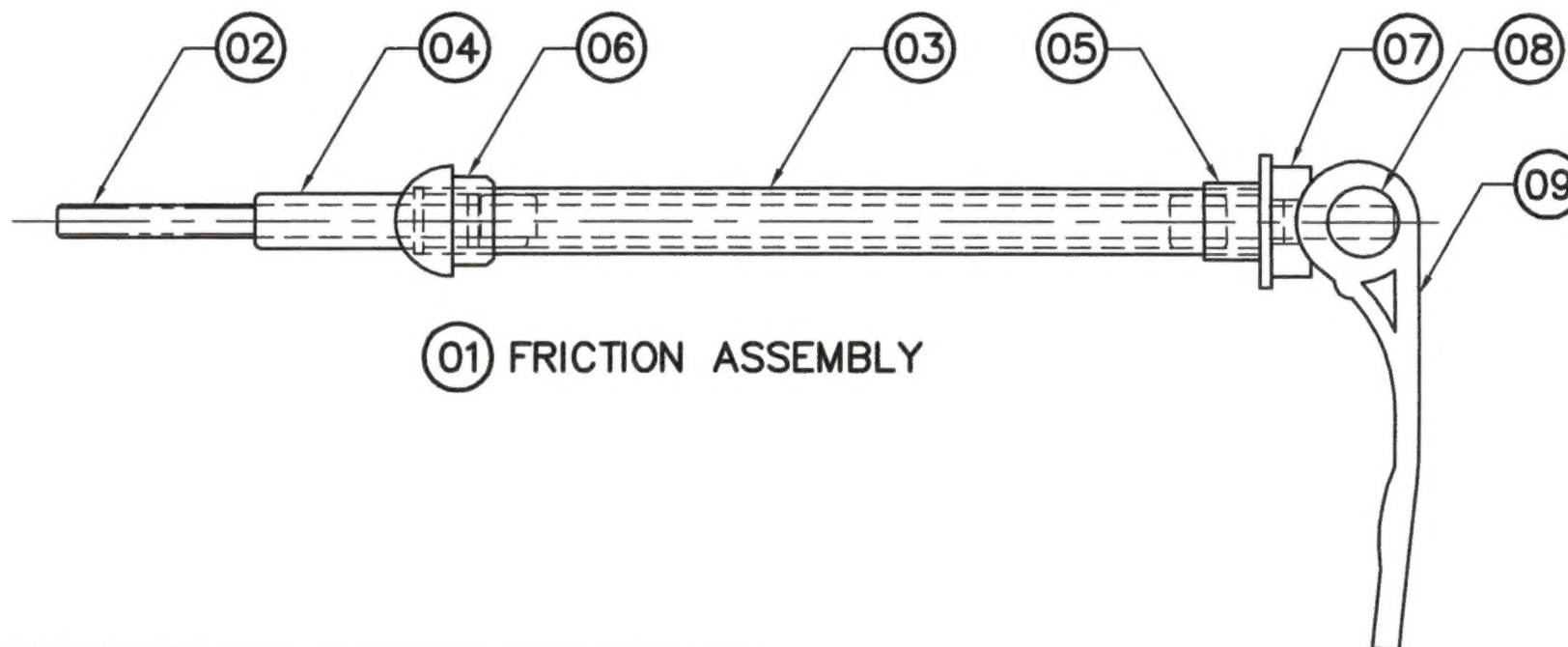
2016-97

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; NOTE 1 CORRECTED.	BJC	14/10/2013

## NOTES

1. PRESS RETAINER BUSHING (04) INTO TUBE (03), INSERT THREADED ROD ASSEMBLY (02) INTO TUBE, PRESS CAP (05) ONTO TUBE, THEN PRESS TUBE ASSEMBLY (03, 04, 05) INTO CRESCENT BUSHING (06).
2. SLIDE CURVED WASHER (07) OVER THREADED ROD, INSERT BARREL NUT (08) INTO CAM LEVER (09), THEN THREAD CAM LEVER ONTO THREADED ROD. DO NOT TIGHTEN.



(01) FRICTION ASSEMBLY

1	MODEL 1100	09	CAM LEVER (HYGOAL)
1	95230-01	08	BARREL NUT
1	95228-01	07	CURVED WASHER
1	95226-01	06	CRESCENT BUSHING
1	95224-01	05	CAP
1	95222-01	04	RETAINER BUSHING
1	95220-01	03	TUBE
1	95212-01	02	THREADED ROD ASSEMBLY
1	95210-01	01	FRICTION ASSEMBLY
QTY	PART NO.	ITEM	DESCRIPTION
			LIST OF MATERIALS

APPROVALS	DATE
DRAWN: JEFF CLARKE	18 OCT 2012
CHECKED: E. BURGAIN	18 OCT 2012
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS                      ANGLES X.XXX ±0.010                  ±1/2° X.XX ±0.03 X.X ±0.1	



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POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 604.483.2376      www.aerodesign.ca

BELL 206B, 206L SERIES, 407  
CYCLIC FRICTION REPLACEMENT  
FRICTION ASSEMBLY

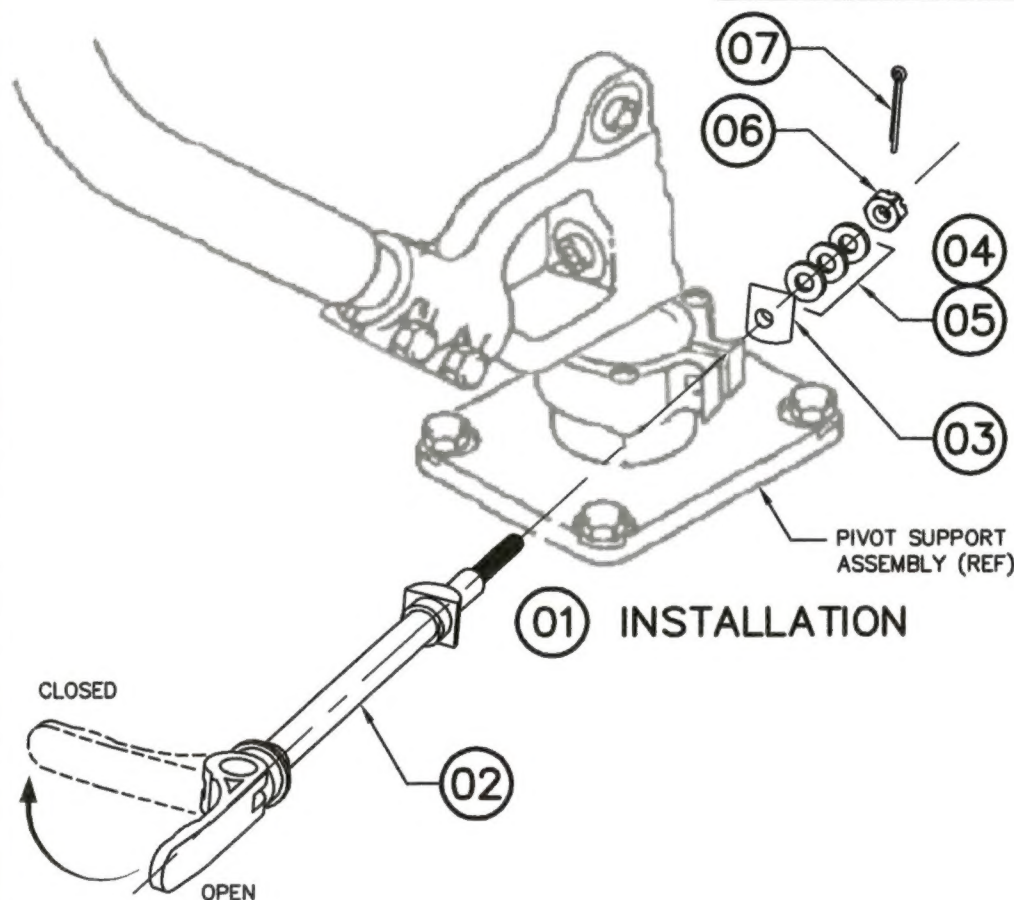
SCALE	DWG. SIZE	DWG. NO.	REV.
SCALE 1 : 1	A4	95210	1
SHEET 1 OF 1			



2016-97

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; P/N'S REMOVED FROM NOTE 2.; NOTE 2.E.; NOTE 3	BJC	31/12/2014



## NOTES

- REMOVE THE EXISTING CYCLIC FRICTION ASSEMBLY AS FOLLOWS:
  - REMOVE PILOT SEAT AND SEAT PANEL. REFER TO MAINTENANCE MANUAL CHAPTER 25.
  - REMOVE COTTER PIN, NUT AND WASHERS AT BOTTOM OF CYCLIC FRICTION KNOB AND SHAFT ASSEMBLY.
  - UNTHREAD BARREL NUTS FROM KNOB AND SHAFT ASSEMBLY.
  - REMOVE KNOB AND SHAFT ASSEMBLY FROM PIVOT SUPPORT ASSEMBLY, AND SLIDE OUT OF CYCLIC STICK BOOT.
- INSTALL NEW CYCLIC FRICTION ASSEMBLY (02) AS FOLLOWS:
  - SLIDE CYCLIC FRICTION ASSEMBLY (02) THROUGH CYCLIC BOOT, SEAT CURVED END INTO PIVOT SUPPORT ASSEMBLY.
  - SLIDE CURVED WASHER (03) ONTO THREADED END OF CYCLIC FRICTION.
  - SLIDE WASHERS (04/05) (AS REQUIRED, SEE E.) ONTO THREADED END OF CYCLIC FRICTION.
  - THREAD CASTLE NUT (06) ONTO THREADED END OF CYCLIC FRICTION.
  - WITH FLIGHT CONTROLS DISCONNECTED OR HYDRAULIC POWER CART CONNECTED, SET FRICTION LEVER IN OPEN POSITION (STRAIGHT OUT), ADJUST MINIMUM FRICTION BY TIGHTENING NUT (06) FINGER TIGHT UNTIL A SPRING SCALE, APPLIED AT THE CENTER OF THE GRIP, INDICATES A BREAKAWAY FORCE OF  $1.0 \pm 0.5$  LBS ( $4.4 \pm 2.2$  N). A MAXIMUM OF 8 WASHERS (04/05) MAY BE USED TO POSITION NUT IN LINE WITH COTTER PIN HOLE IN ROD.
  - SAFETY THE NUT (06) WITH COTTER PIN (07) IN ACCORDANCE WITH AC43.13-1B, SECTION 7-127.
  - INSTALL PILOT SEAT AND SEAT PANEL. REFER TO MAINTENANCE MANUAL CHAPTER 25.
  - PILOT MAY INCREASE FRICTION BY FOLDING LEVER TO CLOSED POSITION.
- ELIGIBILITY: 206B - S/N 1658 AND SUBSEQUENT  
206L, L-1, L-3, L-4 - ALL  
407 - ALL

APPROVALS	DATE
DRAWN: JEFF CLARKE	25 OCT 2012
CHECKED: E. BURGOIN	01 NOV 2012

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:

DECIMALS	ANGLES
X.XXX $\pm 0.010$	$\pm 1/2^\circ$
X.XX $\pm 0.03$	
X.X $\pm 0.1$	



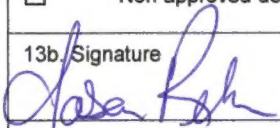
# AERO DESIGN LTD.

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TEL: 804.483.2376 [www.aerodesign.ca](http://www.aerodesign.ca)

BELL 206B, 206L SERIES, 407  
CYCLIC FRICTION REPLACEMENT  
INSTALLATION

QTY	PART NO.	ITEM	DESCRIPTION
1	MS24665-153	07	COTTER PIN
1	AN310-3	06	CASTLE NUT
A/R	NAS1149F0332P	05	WASHER (LIGHT)
A/R	NAS1149F0363P	04	WASHER
1	95238-01	03	CURVED WASHER
1	95210-01	02	CYCLIC FRICTION ASSEMBLY
1	95201-01	01	CYCLIC FRICTION INSTALLATION
LIST OF MATERIALS			

NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	95201	1

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No. <b>2016-0117</b>
4. Organization Name and Address <b>Aero Design Ltd. – 9888A Malaspina Rd., Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2016-97</b>
6. Item	7. Description <b>Cyclic Friction Ass'y</b>	8. Part Number <b>95210-01</b>	9. Qty. <b>2</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<del>14a. <input type="checkbox"/> CAR 571.10 Maintenance Release</del> <del><input type="checkbox"/> Other regulation specified in block 12</del> <del>Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.</del>		
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		<del>14b. Signature</del>	
13d. Name <b>Jason Rekve - AD01</b>		13e. Date (dd/mmm/yyyy) <b>02 Aug 2016</b>		<del>14c. Approved Organization Number</del>	
				<del>14d. Name</del>	
				<del>14e. Date (dd/mmm/yyyy)</del>	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

*EXPEDITION HELI*



[illegible]